

Date: Wednesday, 7/4/2007 3:45:23 PM  
 User: Eric Charbonneau

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET ASS'Y
Job Number	: 33301		
Estimate Number	: 12523		
P.O. Number	: N/A	Part Number	: D35313
This Issue	: 7/4/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: UNDER REVIEW
First Issue	: N/A	Project Number	: N/A
Previous Run	: 32208	Drawing Revision	: N/A
	Type : SMALL /MED FAB	Material	: N/A
Written By	: <u>JS 07-07-12</u>	Due Date	: 7/11/2007
Checked & Approved By	:	Qty:	1 Um: Each
Comment	: Est Rev:A New Issue 06-09-06 EC		

**PROTOTYPE**

## Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S040	6061-T6 .040 Sheet
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Comment: Qty.: 0.1379 sf(s)/Unit Total : 0.1379 sf(s)

6061-T6 .040 Sheet

(M6061T6S040)

Batch: M 103321IB 07-07-06

CERTIFICATE OF CONFORMITY  
REQUIRED

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3531

Dwg Rev: PRELProg Rev: PREL

2-Deburr if necessary

IB 07-07-06WF07-07-07(PTD)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

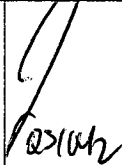
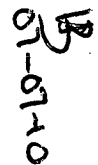

Deburr if necessary.

IB 07-07-10

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3531-3 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PA Date: 07/07/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 33301		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/07/10	# 2.0	1 Part SCRAP. Defect wrong mat used (0.050" instead of 0.040")  R.C. Human Error		Scrap and Destroy with correct mat. - Remind Employee to be more cautious when pulling mat.  BATCH # <del>102723</del> M100742	 07-07-10	En 07/07/10	 07/07/10	En 07/07/10

NOTE: Date & initial all entries

Date: Wednesday, 7/4/2007 3:45:23 PM  
User: Eric Charbonneau

## Process Sheet

Customer: OU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASS'Y

Job Number: 33301

Part Number: D35313

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3530

SB 07/07/11 ①

7.0

QC5

FAI NEEDS MORE  
DIMS. BENT  
PART OK  
CB 07.07.11

INSPECT WORK TO CURRENT STEP

**ENGINEERING  
APPROVAL**



07/07/11

Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

**FOR ENGINEERING USE ONLY**

07.07.19

11.0

QC21

FINAL INSPECTION/W/O RELEASE



07.07.19

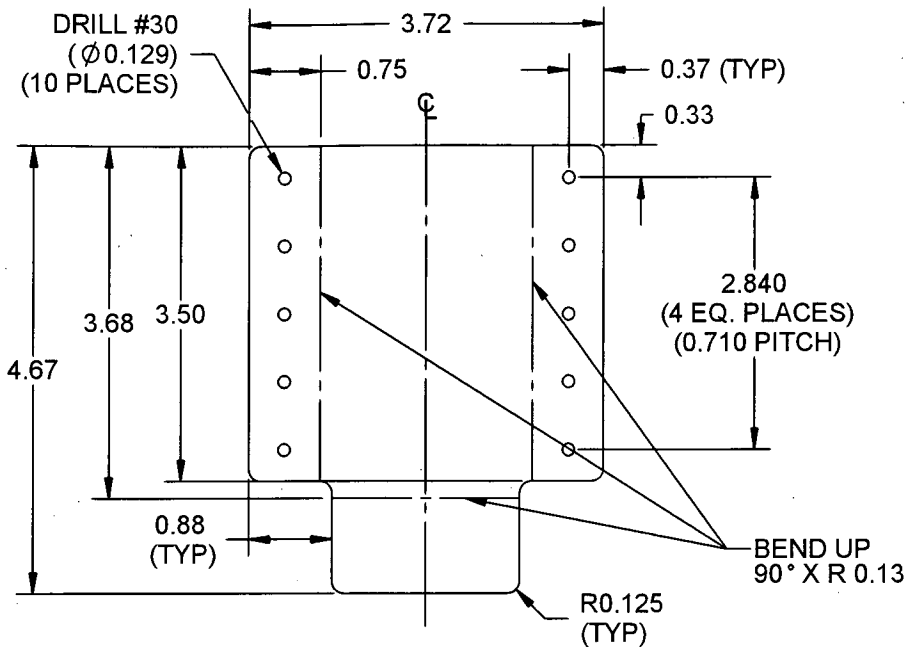
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



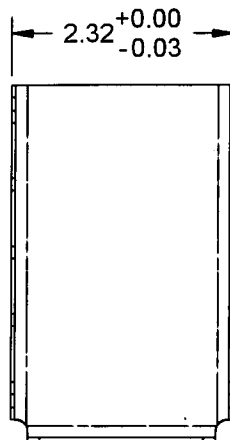
07/07/11

DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>LE</b>	APPROVED	DRAWING NO. <b>D3531</b>	REV. A SHEET 3 OF 3
DATE <b>07.06.19</b>	TITLE <b>BRACKET ASSEMBLY</b>		SCALE 1:2

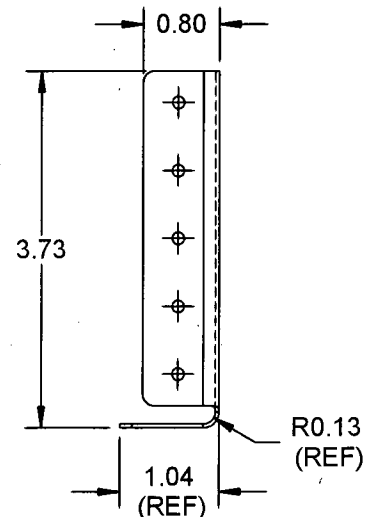


**D3531-3F FLAT PATTERN**

**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
**LE 07.06.22**



**D3531-3 BRACKET FRONT PLATE**



**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT  $\phi$

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# Receiving Report

Date: April 21/06  
 Supplier: Copper & Brass

Batch No: 71100742  
 Dart P/O: 1005

Packing Slip: Yes ☒ No ☐  
 Invoice: Yes ☐ No ☒  
 Receipt: Cash ☐ Cr. ☐

Release Note Attached: Yes ☒ No ☐ N/A ☐  
 Waybill Attached: Yes ☐ No ☐  
 Shipment Complete: Yes ☐ No ☒  
 Q.C. Inspection ☐

Discrepancies						Comments
Part No	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	
M50524325090	Sheet	96	0	0	96	
M6061T6B250X06000		48	0	0	48	
M6061T6B0500X0250		12	10	0	2	

TSR No: \_\_\_\_\_

Initials of receiver (if shipment OK) [Signature]

Production/Admin:

Date:

Received/Costing:

Initial:

THYSS000001Forms\Purchase\RECREPORT rev B

Accounting:

Date:

AP/MR:

Initial:

DESCRIPTION OF MATERIAL	BILLING QTY	UNIT	PRICE	EXTENSION
RECT 6061-T6511 EXTR ALUMINUM BAR 019884 3/8 (+/- .008) X 1 (+/- .0 UZ3803 NO PROCESSING - 144" ML	1.00	PC	138.0700	138.07
PLEASE REMIT IN CANADIAN FUNDS		GST/HST		9.66

INVOICE WILL BE DATED THE DAY OF SHIPMENT. INTEREST WILL BE CHARGED ON PAST DUE ACCOUNTS AT THE RATE OF 1-1/2% PER MONTH. PRICE SHOWN IS SUBJECT TO PRICE IN EFFECT AT THE TIME OF SHIPMENT.

G.S.T. REG. NO. 14022393

TOTAL \$

147.73

REMIT BY: 05/15/06

TERMS: NET 30 DAYS

**EST RESULTS** - - - - -  
**CERTIFICATE OF COMPLIANCE**  
We hereby certify that mercury or any of its compounds are not used in the processing and distribution of our products.  
Our products we distribute are not hazardous in their received state. For MSDS sheets go to [www.copperandbrass.com/msds](http://www.copperandbrass.com/msds)  
Phone 244-239-5682. We hereby certify that the material above complies with the following specifications:  
AMS 4027                      ASTM-B209  
ROHS COMPLIANT

QTY	QUANTITY UOM	VENDOR	VEND PO	HEAT/LOT	PCS	TAG NO	QUANTITY UOM	VENDOR	VEND PO	HEAT/LOT	PCS
	52.00 LB	CORUS	0CC1837	7124901		!					

PRINTED 04/19/06 03:02 PM CONTROL NO 00049